



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

646.9713
Job Sheet 180564



Part No: 646.9713

Job Qty: 2 ea

Part Name: Body



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/10/18

Job Tracking No:

Due Date: 8/6/18

Created By: Jesse White

Type: SOLD

Description:

Note: DWG REV E SHEETS 1-4, 7 IPP Rev.A New issue JFS 16/03/08 Verify by: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	8/6/18	8/6/18	0.00	0.00	Start Up Machining-1		
100	Bandsaw	2 pcs	8/6/18	8/6/18	0.00	0.34	Bandsaw1		DAS 18/07/21
110	CNC Vertical Machining	2 pcs	8/6/18	8/6/18	0.60	2.94	HAAS1-1		52 18/07/21
120	QC	2 pcs	8/6/18	8/6/18	0.00	0.00	QC2 Machining-1		9-89 18/07/21
130	QC	2 pcs	8/6/18	8/6/18	0.00	0.00	QC8 Machining-1		18-07-25
140	Outsource	2 pcs	8/6/18	8/6/18			ATG001-VC	5	18-07-25
150	Packaging	2 pcs	8/6/18	8/6/18	0.00	0.00	Packaging2		AUG 08 2018
155	QC	2 pcs	8/6/18	8/6/18	0.00	0.00	QC5		AUG 23 2018
180	Packaging	2 pcs	8/6/18	8/6/18	0.00	0.00	Packaging3-1		6 AUG 27 2018
190	QC21-SA	2 Ea	8/6/18	8/6/18	0.00	0.00	QC21		9-89
Part Op 100 - Cut Blank at 7.425"									
Descriptions: 110 - 1-Machine per folio FB464									
140 - Issue P/O to ATG : 20040596 Anodize, Color Black, Prime as per Dwg 646.9700									
180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***									

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6S1.000X5.000	7075-T6 Sheet1" Thick Plate X 5" Wide	1.2400 ft (.62 ea)	90-Start up Operation	
		7.925 x 7 = 4.341		

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M7075T6S1.000X5.000	1	33	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Body	0.487Inches ± 0.005	0.492 0.482		
2	Body	4.784Inches ± 0.002	4.786 4.782		
3	Body	3.603Inches ± 0.002	3.605 3.601		

4	Body	2.422Inches ± 0.002	2.424 2.420
5	Body	1.400Inches ± 0.002	1.402 1.398
6	Body	0.375Inches ± 0.002	0.377 0.373
7	Body	0.409Inches ± 0.002	0.411 0.407
8	Body	0.350Inches + 0.005 - 0.000	0.355 0.350
9	Body	0.875Inches ± 0.005	0.880 0.870
10	Body	1.067Inches ± 0.002	1.069 1.065
11	Body	2.608Inches ± 0.002	2.610 2.606
12	Body	2.750Inches ± 0.002	2.752 2.748
13	Body	2.892Inches ± 0.002	2.894 2.890
14	Body	3.348Inches ± 0.002	3.350 3.346
15	Body	3.597Inches ± 0.002	3.599 3.595
16	Body	3.847Inches ± 0.002	3.849 3.845
17	Body	0.544Inches ± 0.002	0.546 0.542
18	Body	2.195Inches ± 0.002	2.197 2.193
19	Body	3.395Inches ± 0.002	3.397 3.393
20	Body	3.495Inches ± 0.002	3.497 3.493
21	Body	4.595Inches ± 0.002	4.597 4.593
22	Body	4.687Inches ± 0.002	4.689 4.685
23	Body	4.734Inches ± 0.002	4.736 4.732
24	Body	0.177Inches + 0.005 - 0.001	0.182 0.176
25	Body	0.201Inches + 0.005 - 0.001	0.206 0.200
26	Body	0.130Inches ± 0.010	0.140 0.120
27	Body	45.0Angle ± 0.5	45.5 44.5
28	Body	1.5Angle ± 0.0	1.5 1.5
29	Body	0.660Inches ± 0.005	0.665 0.655
30	Body	0.660Inches ± 0.005	0.665 0.655
31	Body	0.700Inches ± 0.005	0.705 0.695
32	Body	5.500Inches ± 0.005	5.505 5.495
33	Body	6.8Angle ± 0.5	7.3 6.3

Plex 7/10/18 10:40 AM dart.white.jesse

DART AEROSPACE LTD		Work Order: 180564
Description: Body		Part Number: 646.9713
Inspection Dwg: 646.9700 Rev: D2		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.487	+/-0.005	0.483	✓		H.G.	
4.784	+/-0.002	4.794	✓		Ver	
3.603	+/-0.002	3.603	✓		Ver	
2.422	+/-0.002	2.422	✓		Ver	
1.400	+/-0.002	1.400	✓		Ver	
0.375	+/-0.002	0.375	✓		Ver	
0.409	+/-0.002	0.411	✓		H.G.	
0.350	+0.005/-0.000	0.351	✓		G.P.	
0.875	+/-0.005	0.878	✓		Ver	
1.067	+/-0.002	1.067	✓		H.G.	
2.608	+/-0.002	2.608	✓		H.G.	
2.750	+/-0.002	2.750	✓		H.G.	
2.892	+/-0.002	2.892	✓		H.G.	
3.348	+/-0.002	3.347	✓		H.G.	
3.597	+/-0.002	3.596	✓		H.G.	
3.847	+/-0.002	3.847	✓		H.G.	
0.544	+/-0.002	0.545	✓		H.G.	
2.195	+/-0.002	2.196	✓		H.G.	
3.395	+/-0.002	3.396	✓		H.G.	
3.495	+/-0.002	3.496	✓		H.G.	
4.595	+/-0.002	4.596	✓		H.G.	
4.687	+/-0.002	4.686	✓		H.G.	
4.734	+/-0.002	4.735	✓		H.G.	
Ø0.177	+0.005/-0.001	Ø.177	✓		G.P.	
Ø0.201	+0.005/-0.001	Ø.201	✓		G.P.	
0.13 x 45°	+/-0.010 x +/-0.5°	0.13 x 45°	✓		Ver	
1.500	+/-0.005	1.501	✓		Ver	
0.660	+/-0.005	0.660	✓		H.G.	
0.660	+/-0.005	0.660	✓		H.G.	
0.700	+/-0.005	0.700	✓		Ver	
5.500	+/-0.005	5.500	✓		Ver	
6.8°	+/-0.5°	6.8°	✓		D.G.	

Measured by: DAS 52	Checked by: De	QC Inspector:
Date: 18/07/21	Date: 18-07-25	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	16.04.05	New Issue	KJ	
B	16.11.24	Dimensions revised	KJ	



QA: mid 18 Jun 2019

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: <u>180564</u>		DISPOSITION		AGAINST DEPARTMENT/PROCESS				Engineering Quality Other	
Part No. <u>646.9713</u>		Rework ☐ Scrap ☒ Use-as-is ☐		Skid-tube Machining ☒ Thermoforming ☐ Large Fab ☐		Cross tube Small Fab ☐ Finishing Composite ☐		Water Jet Prod. Eng. Coord. Rec/Store/Packaging Supplier ☐	
NCR No. <u>19-7154</u>		Suspected Unapproved		QTY Effective: <u>1</u>				MRB (QS1042) Approval <u>9:00 18-12-12</u>	
Date: <u>18-07-20</u>		Step #: <u>110</u>		Description Work Order Deviation		Disposition		Completed By <u>DP 18-07-20</u>	
<u>Thickness 0.875$\pm$.005" to 0.863"</u> <u>Part was not sitting right on 2nd op.</u>				<u>Scrap and replace</u> <u>Batch # 5044630</u>		Lead hand / Supervisor Approval Verification		QC / QA Coordinator Approval <u>9:00 18-12-12</u>	
Root Cause		No Re-Verification		Pressure/Forced Bending		Temperature/Cure Set-up		Power Loss/Surge	
Design ☒		Operator ☐		Centre Not Concentric		BOM/Route		Folio/Program	
Doc/Data ☐		Offset/Setup ☐		Cracks		Broken/Damage/Defect		Grain	
Equip/Tooling ☐		Supplier ☐		Crimp/Kink/Ripple/Wave		Inspection Incomplete/Unqualified		Weld	
Handling/Pre ☐		Training ☐		Cuffs		Contamination		Wrong Stock Pulled	
Material ☐		Use for Testing ☐		Crushing		Counter-sink		Out of Sequence	
Internal Transport ☐		Poor Information ☐		Heat Treat		Cut Too Short		Off-set	
Tribal Knowledge ☐		Rushing ☐		Wave/Twist in Tube		Instructions Incomplete/Unclear		Mislabeled	
LOA ☐		Product Improvement ☐		Marks/Chatter				Fit/Function	
Substation ☐		Process Improvement ☐						Misaligned/off center	
Past Expiry Date ☐		Manufacturing Process ☐							
Misidentified ☐		Past Due ☐		OTHER: ☐				Positioned Wrong	
								Outside Dimensions	
								☒ Over/Under tolerance	
								Part Incorrect	
								Part Lost/Missing	
								Part Moved	
								Drawing	
								Finish	
								Mistread	
								Turning Sequence	



Dart Aerospace Ltd.
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Hawkesbury, ON
K8A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
PO040596

Supplier: ATG001-VC A.T.G. Industries Inc 731 INDUSTRIELLE ROAD ROCKLAND ON K4K 1T2 Canada Phone: 613-446-4544 Fax: 613-446-4556	PO No: PO040596 PO Date: 7/25/18 Due Date: 8/1/18 Purchase Order Revision: Revision Date: Ship-To Contact: Tsimiklis, Chrisoula Phone:
Attention: Lalande, Marc-Andre	Via: Ground Pymt Terms: Net 30 Freight Terms: Special Comments:
Ship To: 1270 Aberdeen Street Hawkesbury ON K8A 1K7 Canada Phone: 613-632-5200	

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	180564	646.9713	Body Issue P/O to ATG : Anodize, Color Black, Prime as per Dwg 646.9700	Firmed	-	8/1/18	6 pcs	0 pcs	6 pcs	\$26.25/pcs	\$157.50
2	172468	RBE350A94-3700-C-05	Bottom -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant As Per Dwg RBE350A94-3700-C-05 Rev. 6 -Certificate of Conformity is required	Firmed	-	8/1/18	50 pcs	0 pcs	50 pcs	\$5.75/pcs	\$287.50
Grand Total:										\$445.00	

Order Notes

CE.

Order Notes
Procurement Quality Clauses A005 right of entry A012 chemical and physical test report A016 personnel qualification A017 raw material identification (as applicable) A022 Apical Processing A024 process certifications A026 certification of material conformance A041 quality management system A042 dart notification by supplier A043 retention of quality documents A048 counterfeit parts avoidance, detection, mitigation and disposition program A049 supplier awareness Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 7/27/18 11:08 AM dart.tsimiklis.chrisoula



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 915736

Date: 03-Aug-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
6 ea	Part: 646.9713 Rev: D Body Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 23513 PO: PO040596 Line: 1		
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: 03/08/2018 Certified Signature: [Signature] Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada			